

# Work Order ID 59210

Friday, May 28, 2010 9:22:24 AM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Item Name: Eyebolt Receiver Assembly

Stop



Start Date: 5/27/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3912

A

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

5/30/06/22 (6)

110

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg  
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

5/30/06/22 (6)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/30/06/22

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 59210

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Page 2

Item ID: D3912-041

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Required Date: 6/4/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location: SG7

0.00



Packaging

Memo

0.00

Packaging

6/4/22 (6)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/23

W 10-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, May 28, 2010 9:22:29 AM

Page 1

Work Order ID: 59210

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly


Comments: IPP RevA: new issue DD 09.11.18 verified by:EC

Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21209C6-10  Heli Coil, screw locking, red		Purchased	No				Each	52.0000	1	6			

Location Loc Qty Loc Code

ST304 18  
108847 16  
113705 2  
ST305 34  
114310 34

D3912-3  Eyebolt Block		Manufactured	No				Each	0.0000	2	12			
---	--	--------------	----	--	--	--	------	--------	---	----	--	--	--

100 B59430 (12K) 15.0000

D3912-5  Eyebolt Plate		Manufactured	No				Each	15.0000	2	12			
---	--	--------------	----	--	--	--	------	---------	---	----	--	--	--

Location Loc Qty Loc Code

ST096 15  
58782 15

D3912-1  Eyebolt		Manufactured	No				Each	0.0000	1	6			
---	--	--------------	----	--	--	--	------	--------	---	---	--	--	--

100 B59441 73.0000

* MS20615-4M20  RIVET		Purchased	No				Each	73.0000	8	48			
--	--	-----------	----	--	--	--	------	---------	---	----	--	--	--

Location Loc Qty Loc Code

ST323 73  
113254 7  
114324 4  
114349 62

*Handwritten notes and signatures:*  
 6/5/10/06/22  
 6/5/10/06/22  
 6/5/10/06/22  
 6/5/10/06/22  
 6/5/10/06/22  
 48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, May 28, 2010 9:22:30 AM

Page 2

Work Order ID: 59210



Parent Item: D3912-041



Parent Item Name: Eyebolt Receiver Assembly

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3810-1		Manufactured	No				Each	24.0000	1	6			
Hand Retractable Spring Plunger													

Location

Loc Qty

Loc Code

ST090

24

54523

1

57319

23

D4028-041

Manufactured No

Each

6.0000

1

6



Spring Pin Lanyard Assembly



Location

Loc Qty

Loc Code

ST109

6

58992

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

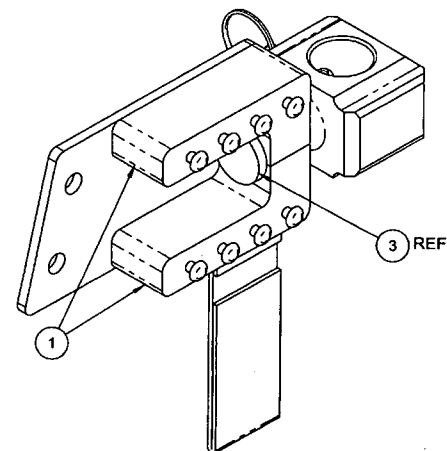
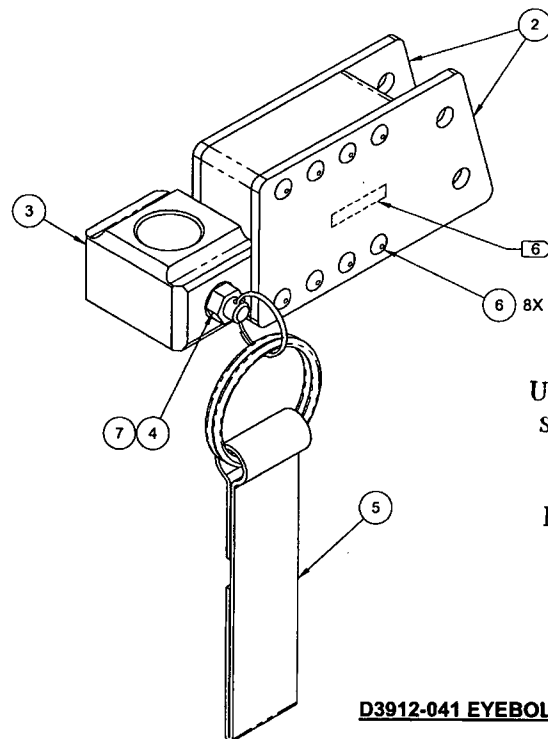
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**NOTE:** Date & initial all entries



ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	2	D3912-3	EYEBOLT BLOCK
2	2	D3912-5	EYEBOLT PLATE
3	1	D3912-1	EYEBOLT
4	1	D3810-1	SPRING PLUNGER
5	1	D4028-041	SPRING PIN LANYARD ASSY
6	8	MS20615-4M20	RIVET
7	1	MS21209-C610	HELICAL (RED LOCKING)



**SUPPLEMENTAL ISO VIEW**  
(EYEBOLT PLATE REMOVED  
TO SHOW INTERIOR FEATURES)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59210  
BS-0-5-28

**D3912-041 EYEBOLT RECEIVER ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.68 lbs

**RELEASED**  
2010-03-12  
MP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. A
CHECKED	JP	D3912	SHEET 1 OF 3
MFG. APPR.	JP	TITLE	SCALE
APPROVED	MP	EYEBOLT RECEIVER ASSY	NTS
DE APPR.	MP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.03.04		

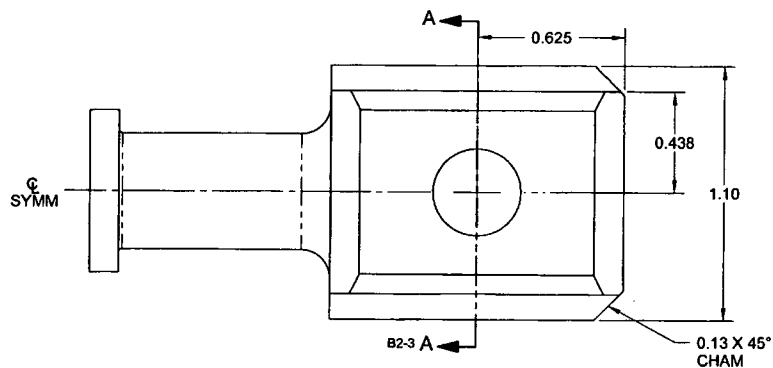
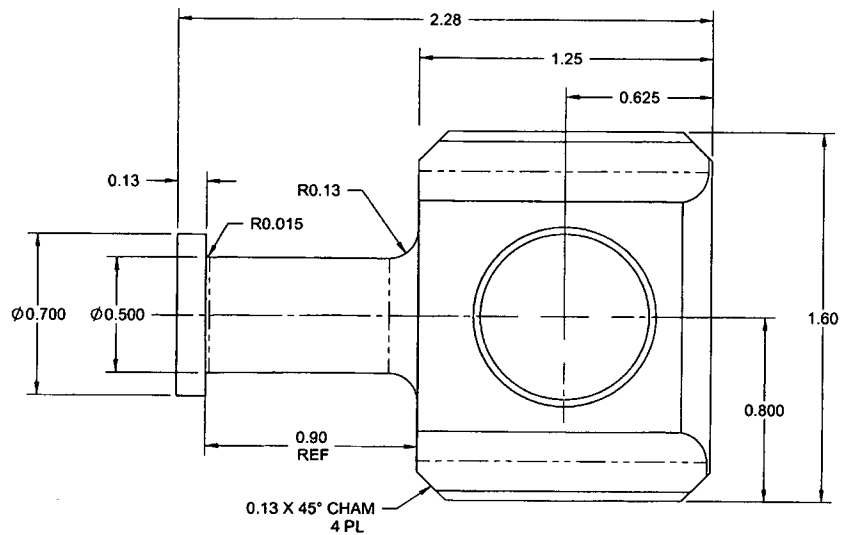
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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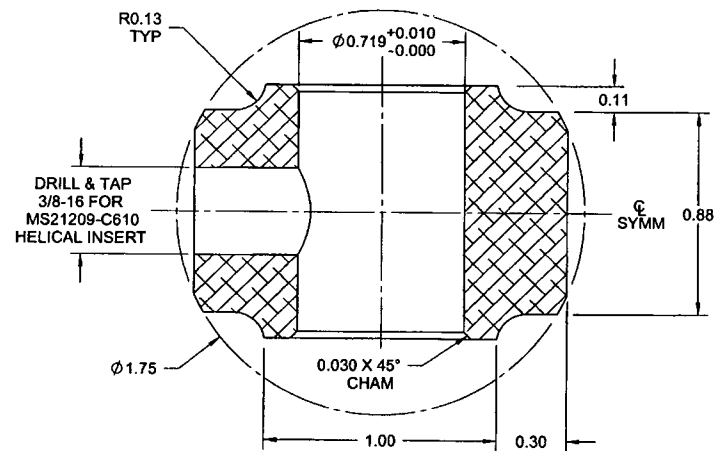
**NOTE:** Date & initial all entries



### D3912-1 EYEBOLT

#### NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.49 lbs



### SECTION A-A B6-3

**RELEASED**  
2010-03-12  
JWP

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D3912	SHEET 2 OF 3
APPROVED	JPH	TITLE	SCALE
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DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/059210

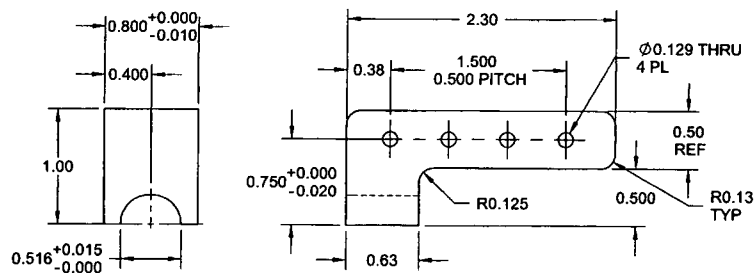
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

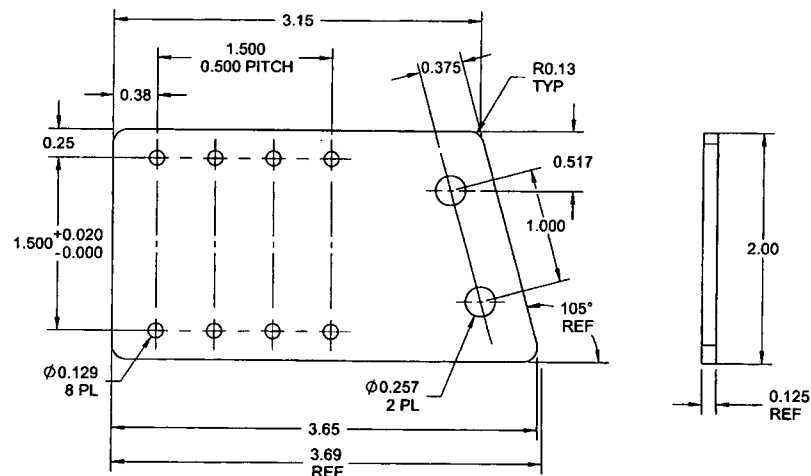
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3912-3 EYEBOLT BLOCK**



**D3912-5 EYEBOLT PLATE**

**NOTES:**

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240  
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs  
-5: 0.24 lbs

*w/o 39210*

**RELEASED**  
2010-03-12  
*WMP*

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3912	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	EYEBOLT RECEIVER ASSY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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